

Abstract:

5 A method of manufacturing metal fins suitable for use in a heat exchanger
which includes providing a coated patterned fin stock having a series of parallel
stripes disposed longitudinally across the width of one surface of the fin stock. The
stripe pattern is evenly spaced in the central portion of the fin stock, and staggered
or more further spaced apart at the edges of said fin stock. The fin stock is passed
through a series of forming dies to form or draw a plurality of tube receiving
10 collared holes in the fin stock, followed by slitting or cutting the fin stock
longitudinally to form a plurality of fin strips. The staggered spacing compensates
for transverse movement of the fin stock during the drawing operation, and assures
for accurate positioning of the collars between the fin stripes. The invention also
includes the use of the fins in a high density coil design for use in a heat exchanger.